

Work Order ID 117271

May-15-14 1:08:03 PM

117271

Rev D Small
PRELIMINARY ISSUE

Page 1

Item ID: D2263-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Release 5 Stop *NS2*
 Item Name: Clamp
 Start Date: 5/15/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 2.00 *2* Customer:
 Reference: rework - PD1

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2263	PD1 Rev D

130 Small Fab 0.00

130

Small Fab

Small Fab

Memo

PULL FROM STK:
2 X D2263-1 B16733

APPLY TEXTURED COATING ON INSIDE SURFACE PER QSI005 4.9
B 127098

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Quality Control

Memo

0.00

DP
4/15/16

2
Impact & pos
Rev - PD1

2 CA 14-05-16

Work Order ID 117271

May-15-14 1:08:03 PM

117271

Page 2

Item ID: D2263-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp
Start Date: 5/15/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/15/14 Req'd Qty: 2.00 ***2*** Customer:
Reference: rework - PD1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

SHIP TO DAVID S. *[Signature]*

14/9/9 *[Signature]*

Wmf 14-5-16

POSITIVE RECALL
EFFECTIVE 11.05.15 AUTH *[Signature]*
RELEASED 14/08/13 DATE *[Signature]*
\$ Rev D Day only.

Picklist Print

Page 1

May-15-14 1:08:02 PM

Work Order ID: 117271

117271

Parent Item: D2263-1

D2263-1

Parent Item Name: Clamp

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP: B01.06.08Now laser cutEC

IPP REV:C 14.05.13

NOW TEXTURE COATING DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2263-1

Manufactured

No

Each

72.0000

2

D2263-1

**

Clamp

Location

Loc Qty

Loc Code

Mezz

72

14579

2

16733

70

2

h

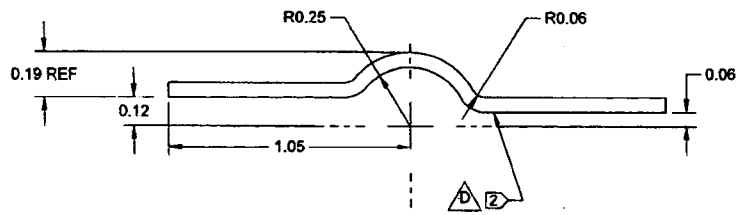
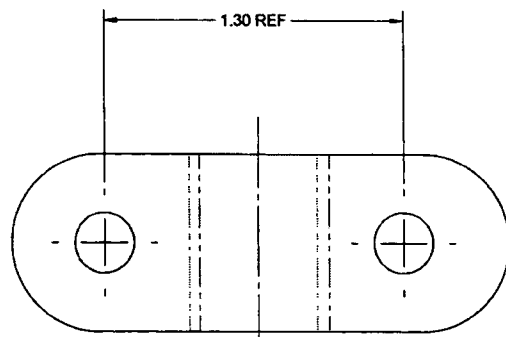
8 7 6 5 4 3 2 1

D

C

B

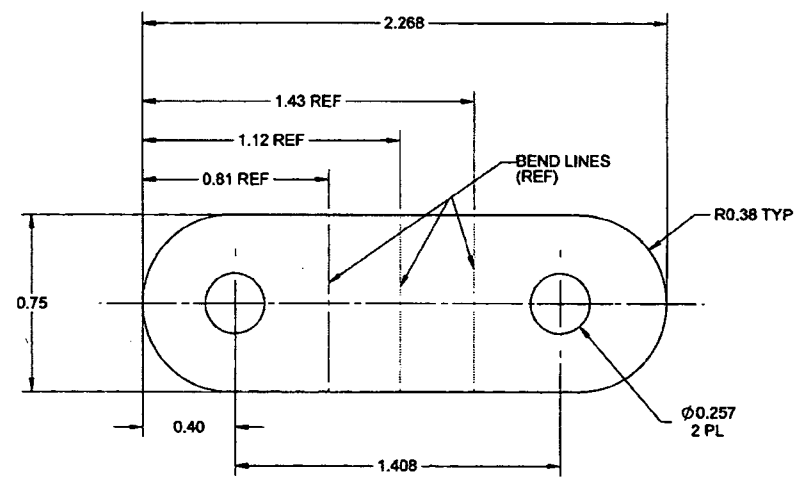
A



D2263-1 CLAMP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 16 GAUGE 0.063 THICK, (REF DART SPEC M304S16GA)
- 2) FINISH: APPLY TEXTURED COATING ON INSIDE SURFACE PER QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: BAG AND TAG WITH DART P/N "D2263-1" PER QSI 044 6.7
- 7) WEIGHT: 0.03 lbs

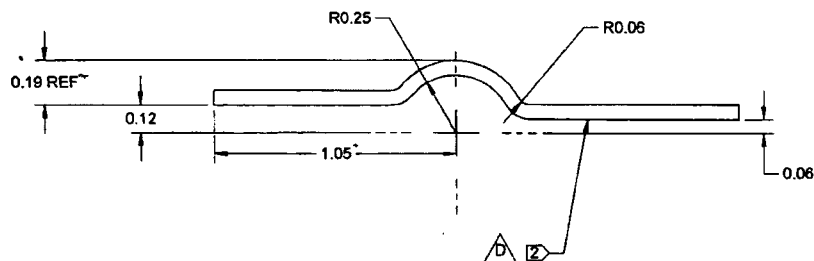
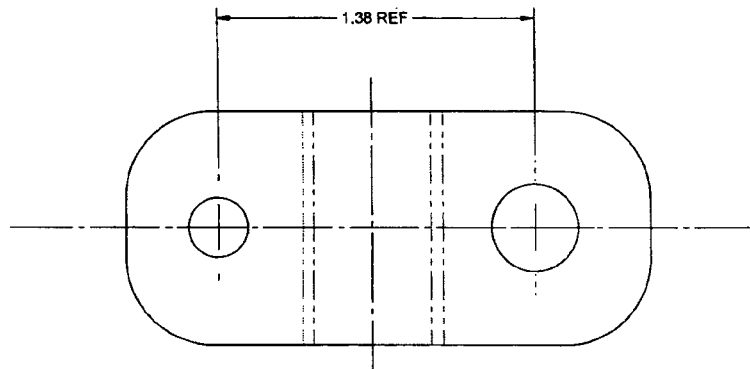


D2263-1F FLAT PATTERN

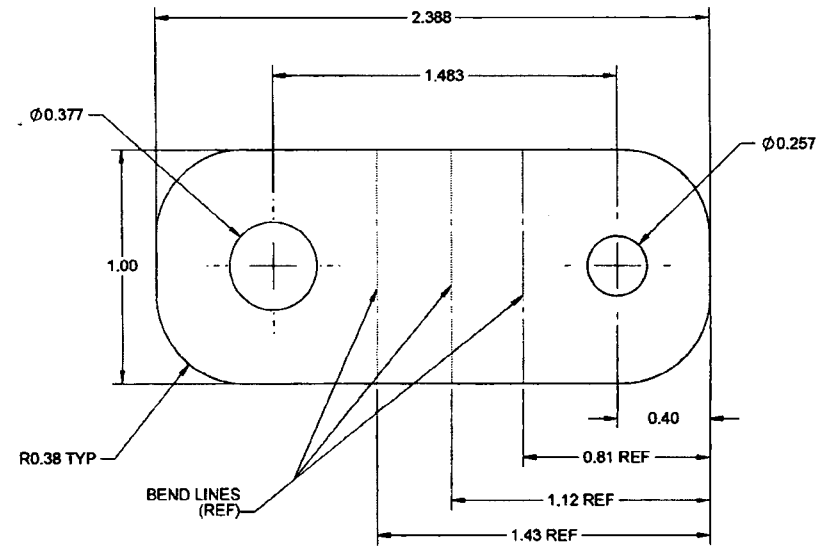
*WLO
4727H*

APPROVED

D	RE-FORMAT DWG, ADD NOTE 2 (TEXTURED COATING)	DB	14.04.28
C	CREATE D2263-1/3	HS	01.03.13
B	REDRAWN	HS	99.06.08
A	NEW ISSUE	JB	94.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2263	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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D2263-3 CLAMP



D2263-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 16 GAUGE 0.063 THICK, (REF DART SPEC M304S16GA)
- 2) FINISH: APPLY TEXTURED COATING ON INSIDE SURFACE PER QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: BAG AND TAG WITH DART P/N "D2263-3" PER QSI 044 6.7
- 7) WEIGHT: 0.08 lbs

APPROVED

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG APPR.	JLM	D2263	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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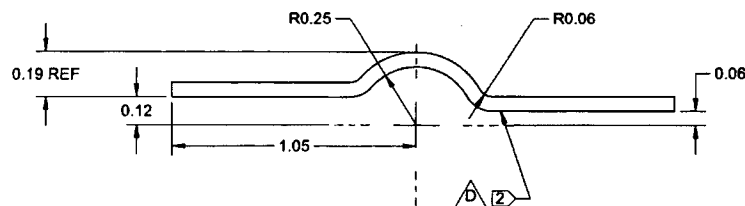
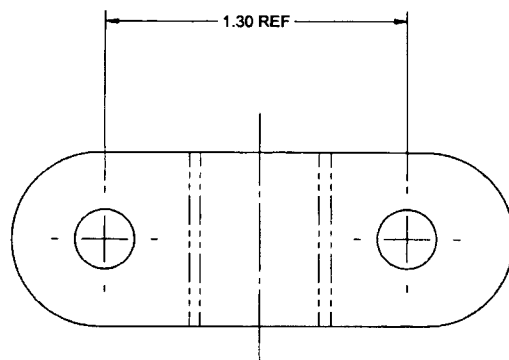
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D

C

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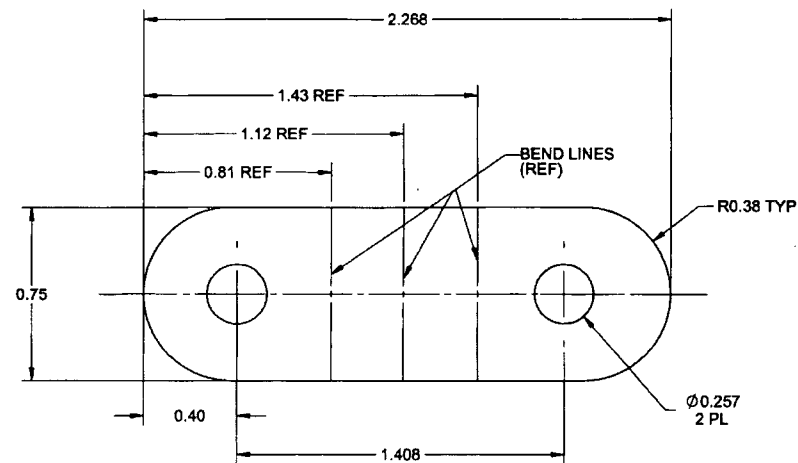
A



D2263-1 CLAMP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 16 GAUGE 0.063 THICK (REF DART SPEC M304S16GA)
- 2) FINISH: APPLY TEXTURED COATING ON INSIDE SURFACE PER QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: BAG AND TAG WITH DART P/N "D2263-1" PER QSI 044 6.7
- 7) WEIGHT: 0.03 lbs



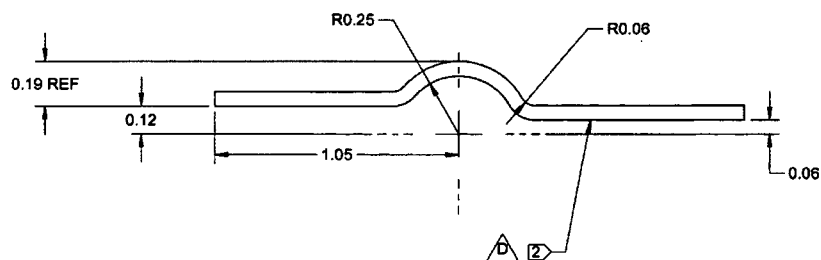
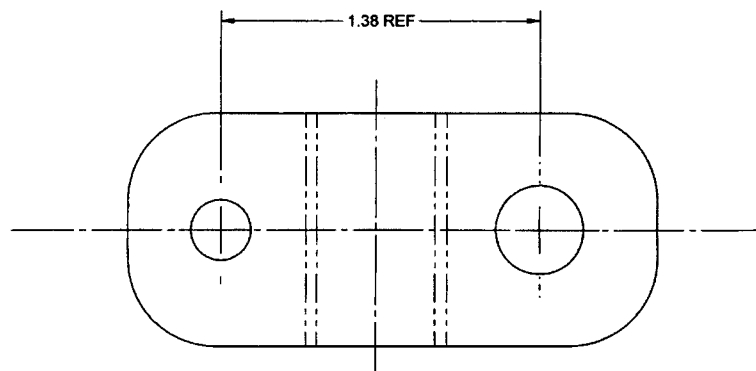
D2263-1F FLAT PATTERN

RELEASED
2014-08-27

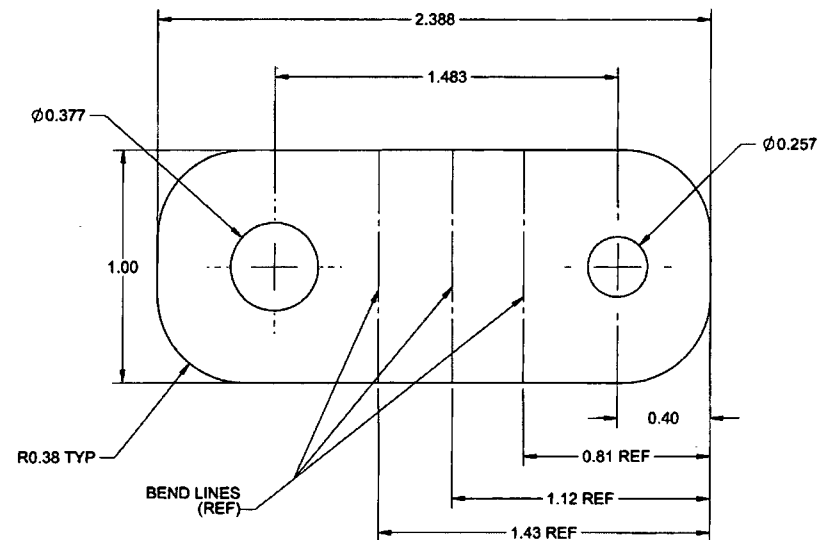
D	RE-FORMAT DWG, ADD NOTE 2 (TEXTURED COATING)	DB	14.04.28
C	CREATE D2263-1/3	HS	01.03.13
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REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2263	SHEET 1 OF 2
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8 7 6 5 4 3 2 1



D2263-3 CLAMP



D2263-3F FLAT PATTERN

RELEASED
2014-08-27

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 16 GAUGE 0.063 THICK, (REF DART SPEC M304S16GA)
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 - 6) IDENTIFICATION: BAG AND TAG WITH DART P/N "D2263-3" PER QSI 044 6.7
 - 7) WEIGHT: 0.08 lbs

APPROVED	DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D2263	SHEET 2 OF 2
	APPROVED	MP	TITLE	SCALE
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